

Work Order ID 48138

Friday, June 26, 2009 8:57:40 AM



Page 1

Item ID: D3459-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Float Step Mounting Plate

Start Date: 7/15/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3459	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3459 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

WB 9-7-2

Deburr m.p. 09/07/06 (20) (20)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

WB 9-7-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8/07/06 (20) (20) counters

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Page 2

Item ID: D3459-1

Accept

Setup Start

Revision ID: A

Stop

Item Name: Float Step Mounting Plate

Start Date: 7/15/2009 Start Qty: 20.00

Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *LWA*

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*9/7/06 200 SP**MF 09-07-08**09/07/07 HJ*

Picklist Print

Page 1

Friday, June 26, 2009 8:57:39 AM

Work Order ID: 48138



Parent Item: D3459-1RevA



Parent Item Name: Float Step Mounting Plate

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.187X04.00 0		Purchased	No			100	f	0.0000	7.3053			
6061-T6 Bar .178 x 4.00									M 106649 HB 9-7-2			

Date: Friday, 22/05/2009 4:40:15 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FLOAT STEP MOUNTING LUG
Job Number	: 48138		
Estimate Number	: 11747		
P.O. Number	:	Part Number	: D34591
This Issue	: 22/05/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3459 REV A
First Issue	: / /	Project Number	: N/A
Previous Run	: 46987	Drawing Revision	: A
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 29/05/2009
Checked & Approved By	: <u>JULIA DAWSON</u>	Qty:	20
Comment	: Est Rev: A New Issue 06-01-06 JLM Est Rev: B Waterjet 06-05-23 ec	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6B0187X04000	6061-T6 Bar .178 x 4.00
-----	--------------------	-------------------------



Comment: Qty.: 0.3644 f(s)/Unit Total : 7.2870 f(s)

4.00" X .188" BAR

6061-T6

(M6061T6B4.000X.188)

Batch: 106649

IB 9-7-2

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3459

Dwg Rev: 1Prog Rev: 1

IB 9-7-2

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 9-7-2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

20107106 (20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 4:40:15 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP MOUNTING LUG

Job Number: 48138

Part Number: D34591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 48138
Description: Float Step Mounting Plate		Part Number: D3459-1
Inspection Dwg: D3459	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

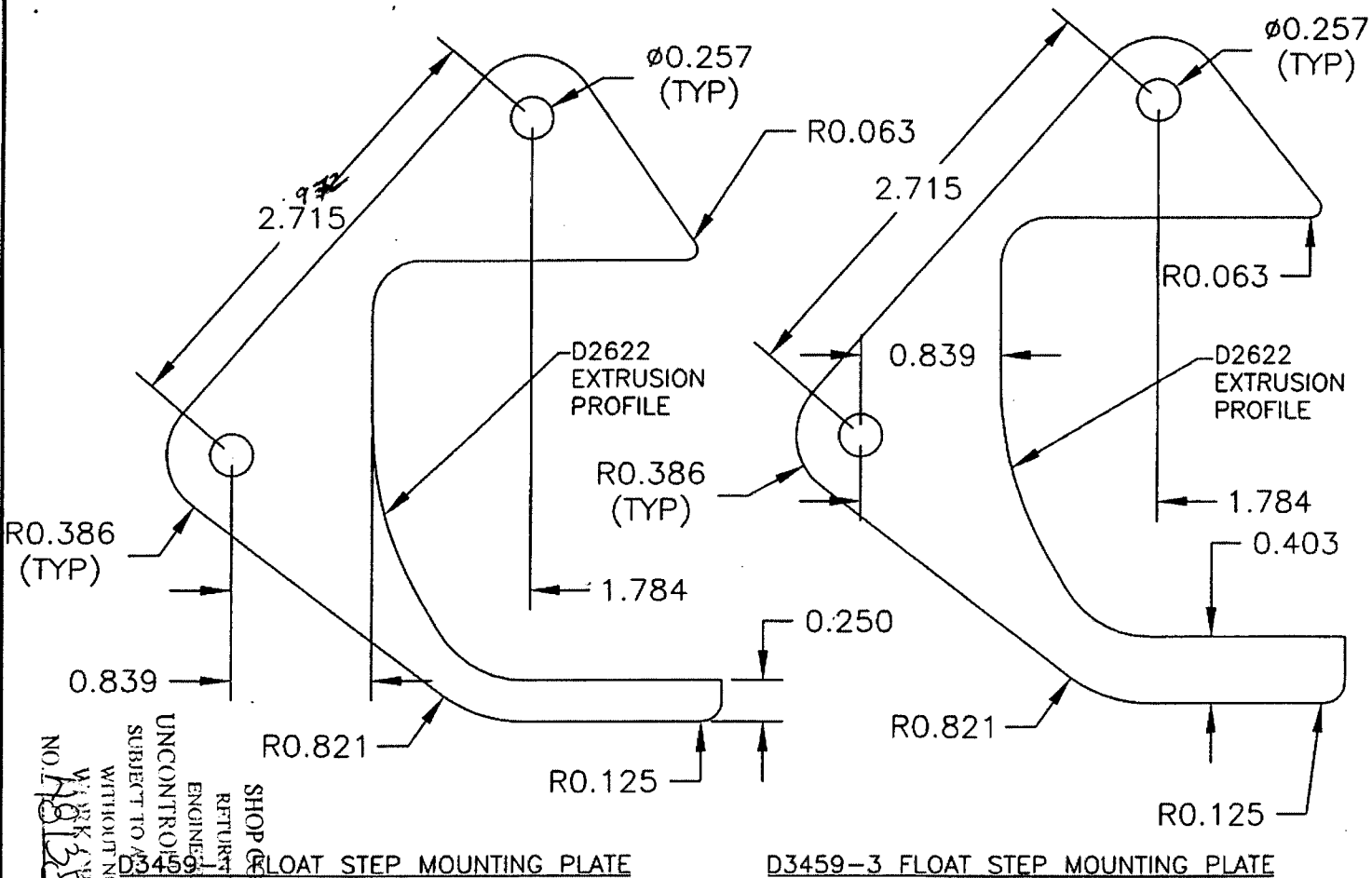
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.006/-0.001	.260	*			
2.715	+/-0.010	2.714	x			
0.250	+/-0.010	.258	x			
R0.125	+/-0.010	.125	x			
R0.063	+/-0.010	.063	x			
0.839	+/-0.010	.839	x			
0.188	+/-0.010	.181	*			

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 9-7-2	Date: 09/07/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.09.26	New Issue	KJ/EC/DD	CE

DART

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
PH	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. A
<i>[Signature]</i>	<i>[Signature]</i>	D3459	SHEET 1 OF 1
DATE	TITLE		SCALE
05.09.23	FLOAT STEP MOUNTING PLATE		1:1
A	05.09.23	NEW ISSUE	



05.11.14

D3459-17-3 FLOAT STEP MOUNTING PLATE

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-250/11) 0.188 THICK
(REF DART SPEC. M6061T6S.188)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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